

Date: Wednesday, 6/27/2007 1:07:20 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP STRUT		
Job Number	: 33209					
Estimate Number	: 11945					
P.O. Number	: N/A		Part Number	: D2017131		
This Issue	: 6/27/2007 S.O. No. : N/A		Drawing Number	: D2017 REV E1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: E1		
Previous Run	: N/A		Material	: N/A		
Written By			Due Date	: 7/10/2007 Qty: 6 Um: Each		
Checked & Approved By						
Comment	: Est F 02.06.19		Update processes (Ref. ECN 435) KJ			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		 Comment: Qty.: 2.7738 f(s)/Unit Total : 16.6427 f(s) Punch tube type 304-2B, $\frac{3}{4}$ " Ø. X .049" wall to length per Dwg. D2017 & spec control D2638 Batch No. <u>1104862</u> FF 07-07-06
		Deburr
2.0	QC5	INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT WORK TO CURRENT STEP SAD 07/07/09 (6)
3.0	POWDER COATING	POWDER COATING
		 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 M 101575 BR 07-07-10
4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 Comment: INSPECT POWDER COAT P 07/17/16 (6)
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 208 P 07/17/16 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:07:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 33209

Part Number: D2017131

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



07.07.16 *JK*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



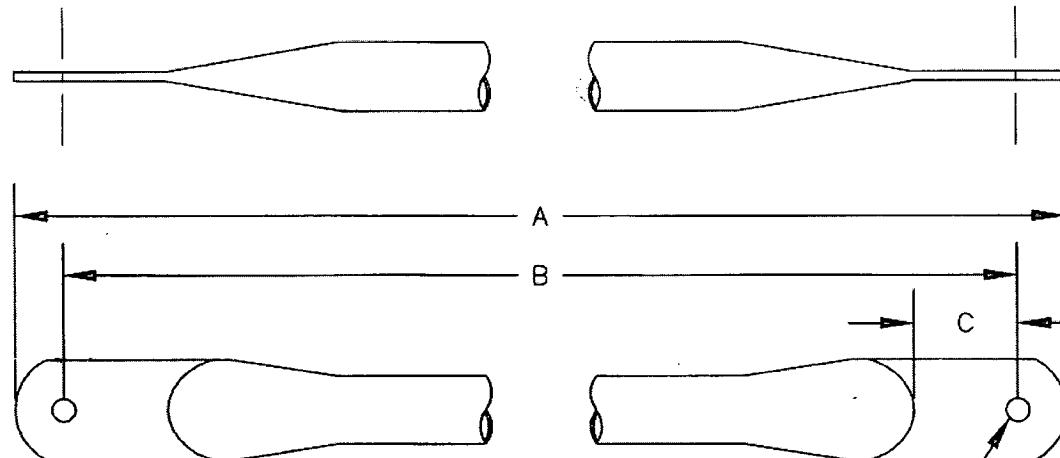
*U D7-07-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

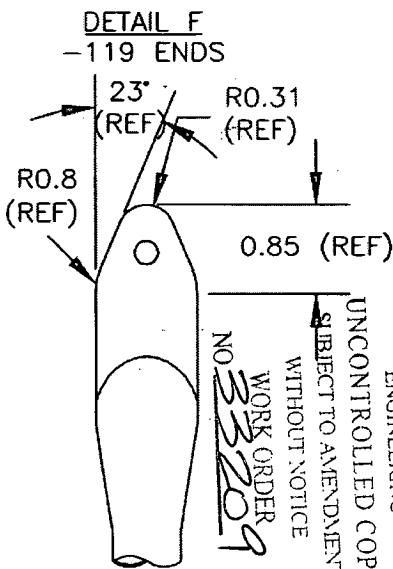
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PUNCH ENDS PER  
SPEC CTRL D2638  
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)  
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)  
BEND FLARED ENDS 8° UP/ 8° DOWN

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 *(E1)*

Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

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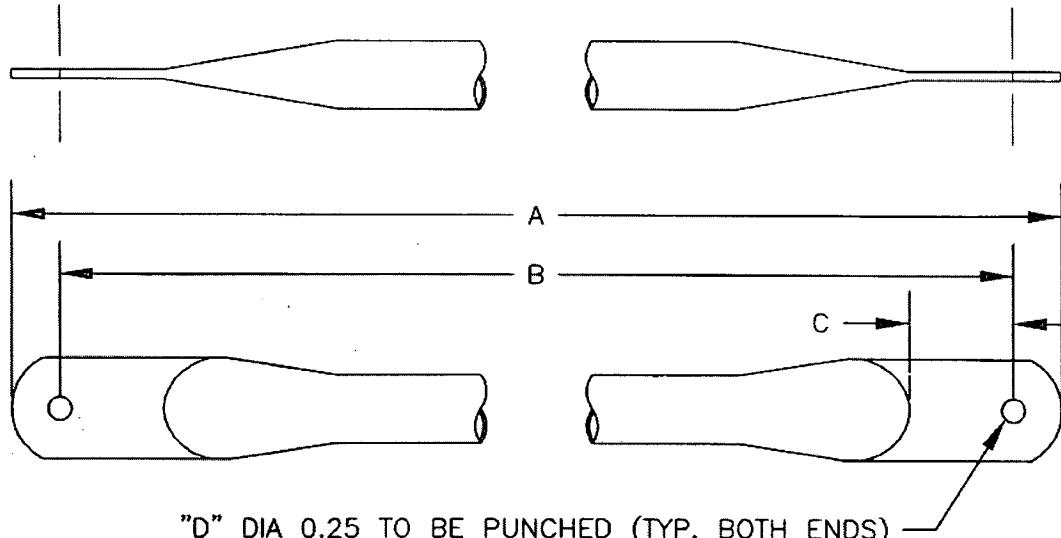
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO 33209

DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>RE</i>	APPROVED <i>TM</i>	DRAWING NO. D2017	REV. E	SHEET 1 OF 2
DATE 99.04.16	TITLE STEP STRUTS	NTS	SCALE	
C	95.01.26	ADDED PARTS		
D	96.03.28	ADD PARTS		
E	99.04.16	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897)		
F1	02.03.22	ADD FINISH		

**DART**

*copy date*



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

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WORK ORDERED  
NO. 33209

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 /EI

RELEASED  
R  
04.05.11  
KE

**DART**

COPY ISSUED  
ORIGIN

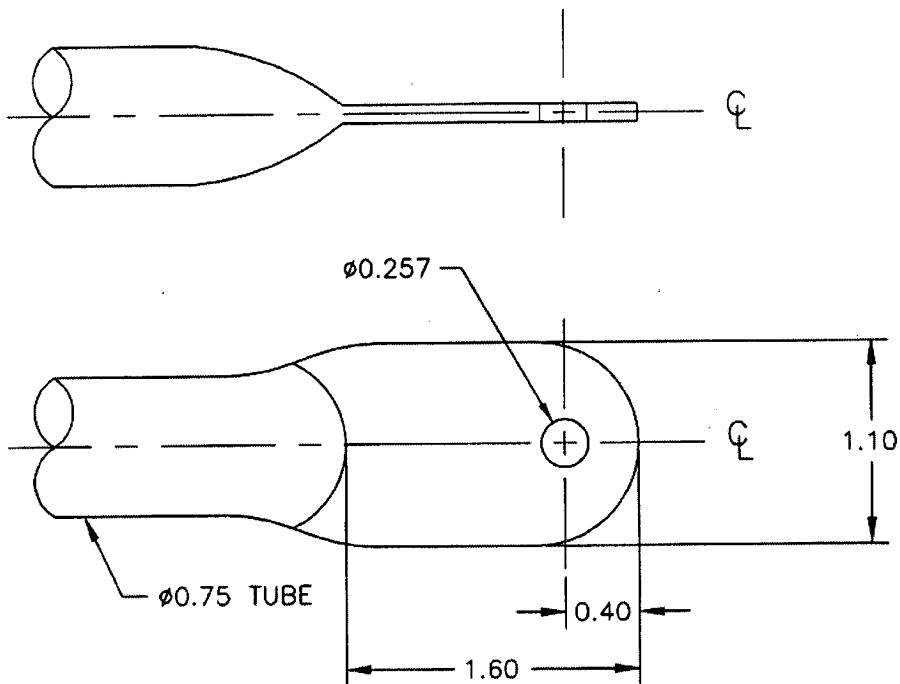
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED W	DRAWING NO. D2017	DATE
99.04.16	STEP STRUTS	TITLE	SCALE NTS

**DART**

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED M	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

**RELEASED**  
98/04/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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